

Date: Tuesday, 23/09/2008 10:22:18 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PLATE		
Job Number	: 42227			Part Number	: D323813	
Estimate Number	: 12563			Drawing Number	: D3238 REV.C	
P.O. Number	:			Project Number	: N/A	
This Issue	: 23/09/2008		S.O. No.	:		
Prsh Rev.	: NC			Drawing Revision	: C	
First Issue	: //		Type	: SMALL /MED FAB		
Previous Run	: 40298			Material	:	
Written By	:			Due Date	: 20/10/2008	
Checked & Approved By	: <u>JUL 08 9.23</u>			Qty:	132	Um: Each
Comment	: Est Rev:A New Issue 06-10-20 EC					
	Est Rev:B Now on Waterjet 07-01-26 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S020	5052-H32 .020 Sheet
Comment: Qty.: 0 sf(s)/Unit Total : 2 sf(s) 5052H32 aluminum sheet 0.020" thin batch: <u>4894</u> <u>B 8-10-7</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3238 Dwg Rev: <u>C</u> <u>B 8-10-7</u> Prog Rev: <u>C</u> <u>B 8-10-7</u>		
Comment: 2-Deburr if necessary <u>cB08/10/08</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 8-10-7</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>S 08/10/08 X/147</u>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>HB</u> <u>08-10-08</u> <u>147</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:18 AM
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Drawing Name: PLATE

Job Number: 42227

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-H 08/10/08

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P. Shultz (147)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/09 ff

Job Completion



L 08/10/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	4227
Description: Plate	Part Number:	D3238-13
Inspection Dwg: D3238	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B	Audited by:	D	Prototype Approval:	N/A
Date:	8-10-7	Date:	08/06/68	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.02.23	Dwg Rev. updated	KJ/JLM	Z

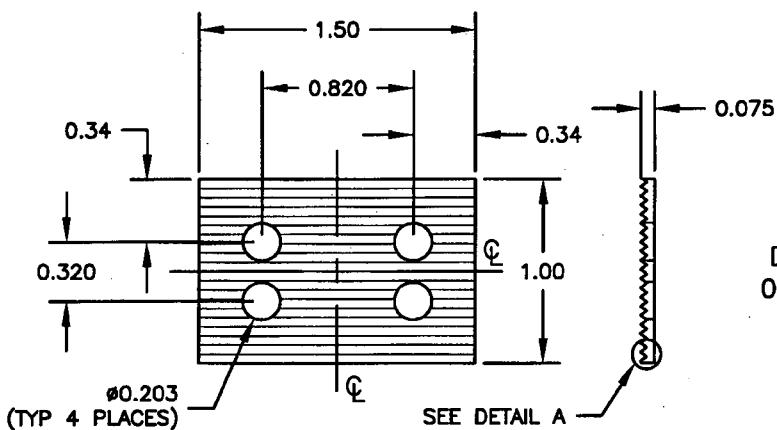
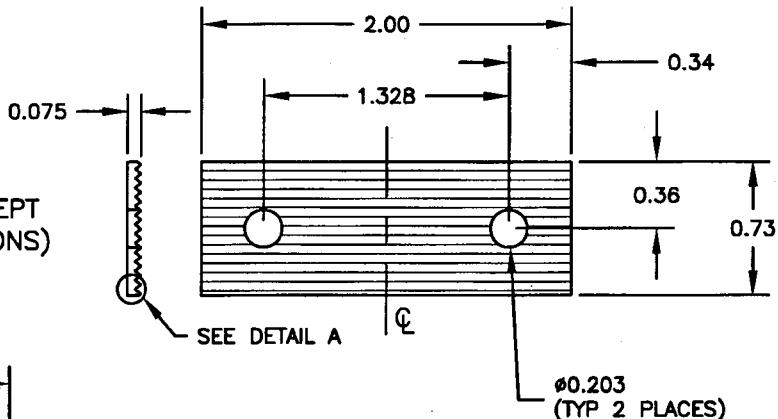
DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED CE	APPROVED	DRAWING NO. D3238
DATE 07.02.19	TITLE PLATE	REV. C SHEET 1 OF 3 SCALE 1:1
A	03.11.25	NEW ISSUE
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6
C	07.02.19	ADD 5052-H32 OPTION

RELEASED

07.02.20

D3238-1 PLATE (SHOWN)
 D3238-11 PLATE (SAME, EXCEPT
 0.020 THICK AND NO SERRATIONS)



D3238-3 PLATE (SHOWN)
 D3238-13 PLATE (SAME, EXCEPT
 0.020 THICK AND NO SERRATIONS)

NOTES:

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
 ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
 (REF DART SPEC M2024T3S)
 -11/-13/-15/-31/-33/-35 PLATE:
 ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
 AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
 OR
 ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
 AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT $\frac{1}{4}$

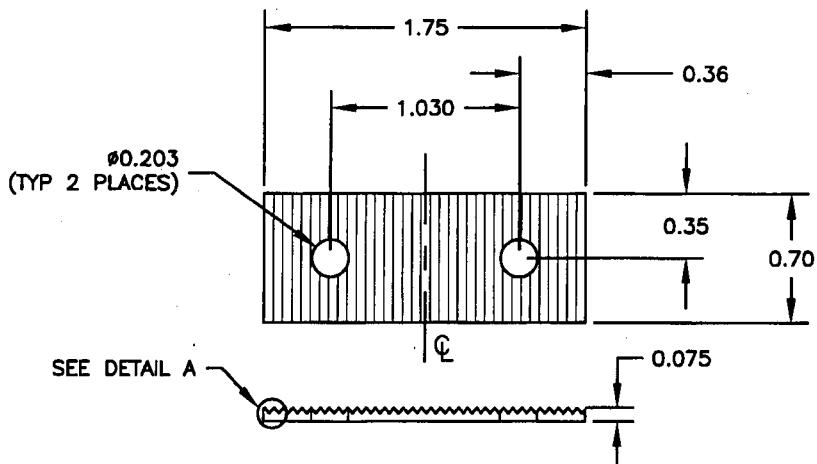
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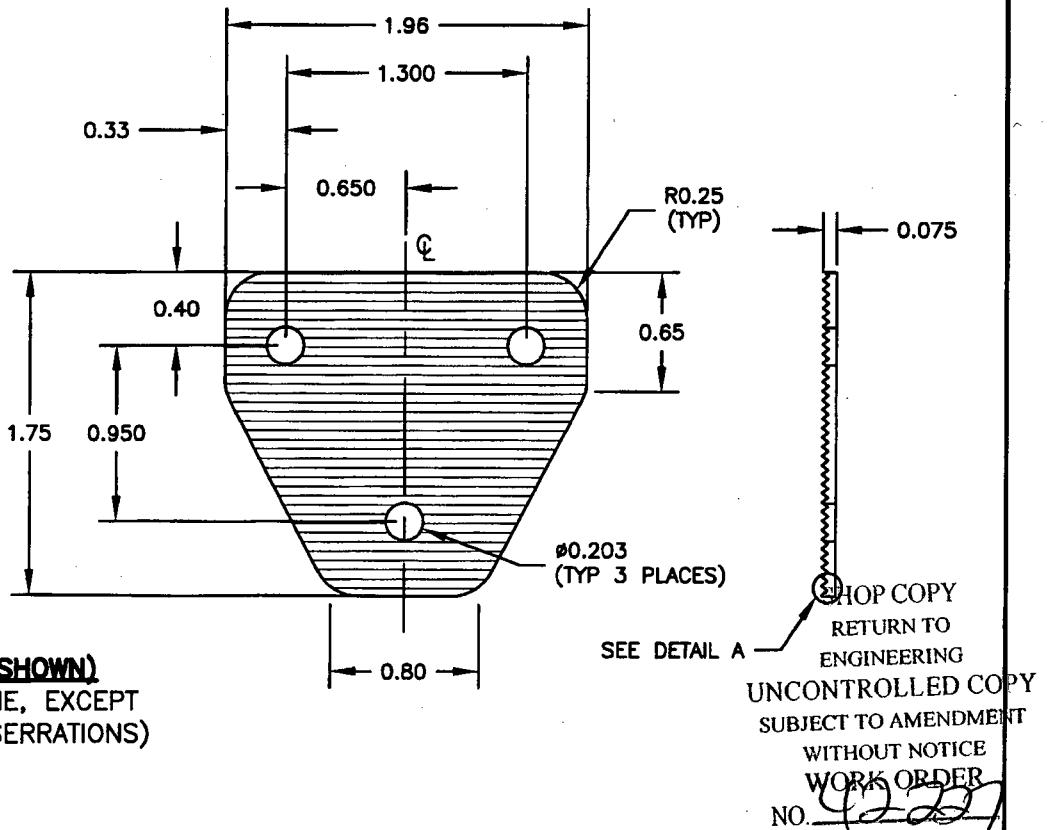
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DART

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>HH</i>	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19	TITLE PLATE	SCALE 1:1	

**RELEASED**c7.02.20 *HH*

D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



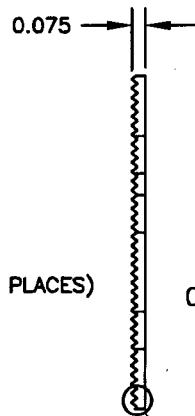
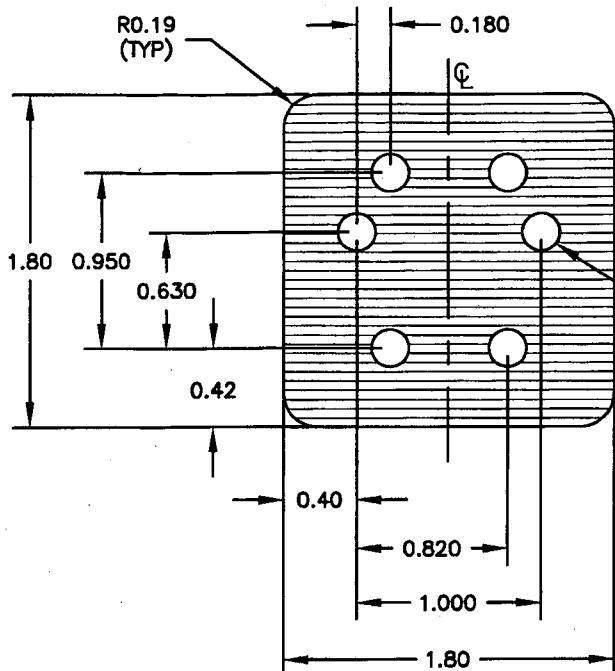
D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

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DART

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>WT</i>	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1

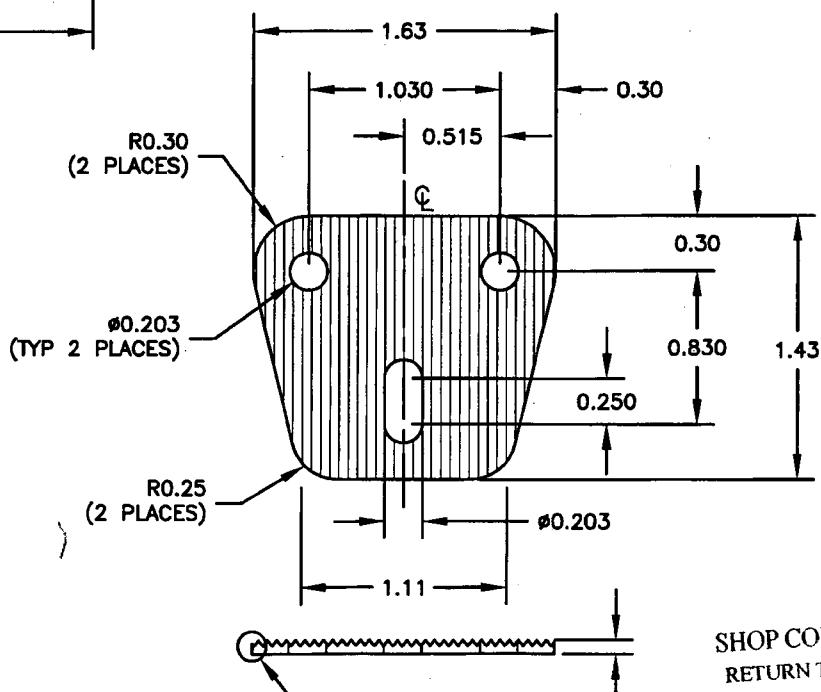
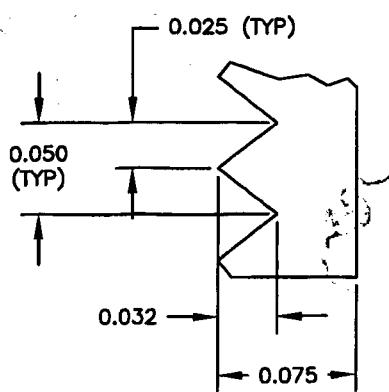


RELEASED

07.02.20 *WT*

D3238-23 PLATE (SHOWN)
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

SEE DETAIL A



SEE DETAIL A

DETAIL A
RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *42220*

D3238-25 PLATE (SHOWN)
D3238-35 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)